

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021325**Date Inspected:** 28-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1100**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Fred Von Hoff**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Section**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and to monitor American Bridge/Fluor (ABF) welding operations.

The following observations were made:

1) At weld joints 10E/11E - OBG sections: ABF personnel were in the process of fitting the transverse weld joints (A thru F). As of 1000 hours this date OBG section 11E was being pulled into position and was approximately 75 mm from OBG section 10E. QC Inspector Tony Sherwood was monitoring the work.

2) At weld joint 9E/10E -B, inside the OBG section: ABF welding personnel Fred Kaddu (#2188) was using the Shielded Metal Arc Welding (SMAW) process to perform repair welding. QC Inspector Steve Jensen was monitoring the work.

3) At weld joint 6EPP32.5E5NW, Access Plate, inside the OBG section: ABF welding personnel Wen Han Yu (#6317) was using the SMAW process for production welding. QC Inspector Fred Von Hoff was monitoring the work.

At OBG sections 10E/11E this QA Inspector randomly observed ABF personnel were in the process of fitting the transverse weld joints (A thru F). As of 1000 hours this date OBG section 11E was being pulled into position and was approximately 75 mm from OBG section 10E. QC Inspector Tony Sherwood was monitoring the work and

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various ABF personnel were setting welding equipment and ventilation in preparation.

At weld joint 9E/10E –B, inside the OBG section this QA Inspector observed ABF welding personnel Fred Kaddu (#2188) using the SMAW process for repair welding. This QA Inspector observed ABF welding personnel Fred Kaddu (#2188) start repair welding at an excavation located at Y-1000. The excavation was 90 mm long and 18 mm deep. Prior to the start of welding this QA Inspector observed ABF welding personnel Fred Kaddu (#2188) using a gas torch to preheat the area and verify the temperature using a temperature indicating marker. This QA Inspector performed a verification of the welding parameters observing; 120 amperes using a 3.2 mm diameter E7018H4R electrode. The welding being performed appeared to comply with Welding Procedure Specification (WPS) ABF-WPS-D15-1001 Repair. This QA Inspector observed an additional excavation for repair welding located at Y-60 with a length of 90 mm and a depth of 14 mm. This QA Inspector observed QC Inspector Steve Jensen monitoring the work.

At weld joint 6EPP32.5E5NW, Access Plate, inside the OBG section this QA Inspector observed ABF welding personnel Wen Han Yu (#6317) using the SMAW process for production welding. This QA Inspector observed grinding and welding in process and performed a verification of the welding parameters observing; 128 amperes using a 3.2 mm diameter E7018H4R electrode. This QA Inspector observed QC Inspector Fred Von Hoff was monitoring the work. The work performed at this location appeared to comply with ABF-WPS-D15-1040B Rev-1 and the contract requirements.

Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) and Caltrans personnel during this shift. Except as described above there were no notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Hager,Craig	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer
